

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013731**Date Inspected:** 02-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY# 14

Deck panel U-rib connecting to Deck plate in segment 12AW, the partial joint penetration (PJP) weld joint is identified as DP3043-001-335,336 and DP3043-001-335,336. ZPMC completed their welding with GMAW process for root pass weld and FCAW process for rest of the weld on 4-30-2010 night shift. When we asked ZPMC QC Mr. Li Ming yang gave the in-process welding

Report, it shows that without proper WPS ZPMC carried out this welding. Regarding this incident this inspector sent an E-mail to our SMR Mr. Jim Simmons.

WPS used for the welding process as follows as per ZPMC report

GMAW: WPS-B-T-2342-U5.

FCAW: WPS-B-T-2232-Tc-U4b-F.

During random visual inspection of deck panel diaphragm connecting with U-ribs of Segment 12AW, it was observed that root gap of fillet weld joint was more than 5mm of following locations weld is identified as DP3044-001-145/146, 155/156, 165/166.

DP3044-001-145/146, 165/166, 093/094.

DP3045-001-165/166, 175/176, 083/084,123/124.

OUTSIDE SHOP

WELDING INSPECTION REPORT

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SMAW welding of repair weld joint 4G-005 located on PCMK SEG066B of Segment 11AE welder is identified as 044779. ZPMC QC is identified as Mr. Tang ya jun . The welding variables recorded by QC appeared to Comply with the WPS-345-SMAW-4G (4F)-FCM-Repair and WR8463.

SMAW welding of weld joint 4G-138 located on PCMK SSD13-PP97 of Segment 11AW welder is identified as 044772. ZPMC QC is identified as Mr. Tang ya jun . The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-B-U4b-FCM.

BLAST SHOP#1

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of Segment 9EE internal Deck panel , floor beams , corner assembly and deck panel diaphragm connecting to floor beam from panel point PP83 to PP85 after grit blasting. Areas that marked for repair were recorded for future repair. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Chadra	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
